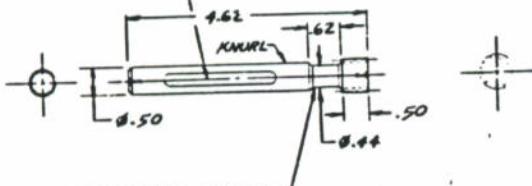


FILE COPY

(FAR) ETCH AS SPECIFIED WITH Y16-Y8 HIGH FIGURES THE FOLLOWING: ALLISON, TOOL NO. AND LAST CHANGE LETTER AND VENDOR NAME CR TRADEMARK

(NEAR)-ETCH "12 T-20/40 P-30° P.A."
(OVERHAUL)



GRIND DIAMETERS MUST BE PARALLEL AND CONCENTRIC WITH PITCH LINE OF SPLINE WITHIN .0002 TOTAL INDICATOR READING

DATA:

NO. OF TEETH - - - - -	12
NORMAL DIAMETRAL PITCH - - - - -	20/40
NORMAL PRESSURE ANGLE - - - - -	30°
EXT OR INT - - - - -	EXT
ARC TOOTH THK - - - - -	0.0823 - 0.0825
PIN DIA - - - - -	0.0864
DIMENSION OVER PINS - - - - -	0.7262 - 0.7265
PITCH DIAMETER - - - - -	0.6400
MAJOR DIA - - - - -	0.6400 - 0.635

MAX ROOT DIA MUST PERMIT
PIN DIA TO LIE ON PROFILE
OF TOOTH

0.550 MAX

.005 R MAX

INVOLUTE MUST BE
TRUE OUTSIDE .550 DIA

NO SCALE

NOTES:

1. COAT WITH GREASE FOR PROTECTION AGAINST CORROSION
2. TOOTH SPACING MUST BE .117-.118-.0002 ACCUMULATED ERROR-TAPER MUST BE WITHIN (.2) P/M TOLERANCE. SPIRAL MUST NOTE ACCUMULATED .0002 IN SPLINE LENGTH DIMENSION OVER (.2) PINS. TO BE WITHIN SPECIFIED TOLERANCE FOR 80% OF THE TEETH. WHEN USING AN ANVIL PRESSURE OF (2) POUNDS - THE REMAINING TEETH MAY BE UNDERSIZE

INVOlUTE

0.0002

42.9°

ROLL BC TO QD

33.1°

ROLL BC TO P.D.

13.9°

ROLL BC TO INVOlUTE DIA

PROFLE MUST LIE WITHIN LIMIT SHOWN BY SHADED AREA ON INVOlUTE CHART

These local governments are encouraged to consult with the teams of the EPA Statewide Assessment program. The appropriate forms or documents are to be submitted in the custody of the assessment and shall not be disclosed by any third party without specific written consent of Interstate Biennial Data Exchange, Division of EPA.

REDUCED
PRINT

EACH ITEM PURCHASED SEPARATELY
MUST BE STAMPED OR ETCHED WITH
TOOL NUMBER AND DETAIL NUMBER.
IF SUITABLE OR SUFFICIENT AREA
NOT AVAILABLE, ATTACH TAG.

USED ON ENGINE MODELS
250 SERIES

GEOMETRIC CHARACTERISTIC TYPE	
<input type="checkbox"/> PLUNGE	<input type="checkbox"/> PARALLELISM
<input type="checkbox"/> PLUNGE OR	<input type="checkbox"/> SIMILARITY
<input type="checkbox"/> PLUNGE	<input type="checkbox"/> ANGULARITY
<input type="checkbox"/> PARALLEL OF A LINE	<input type="checkbox"/> LENGTH
<input type="checkbox"/> PARALLEL OF L +	<input type="checkbox"/> TRUE LENGTH
LINEAR DIMENSION	<input type="checkbox"/> POSITIONALITY
	<input type="checkbox"/> SYMMETRY
UNIQUE FEATURES SPECIFIED	
ALL THESE POSITIONAL TOLERANCES AND RELATED EXPANSION	
AND POSITIONAL TOLERANCES ARE POSITIONAL TOLERANCES AND	

UNLESS OTHERWISE SPECIFIED
 TOL. OR ANGLES = 1°
 TOL. OR 3 PLACE DECIMALS = .001
 TOL. OR 2 PLACE DECIMALS = .02
 TOL. OR 1 PLACE DECIMALS = .2
 TOL. OR 0.1 PLACES = 1
 MATERIAL
TOOL STEEL
 HEAT TREAT AND TEMPERED
HDN 58-62 Re

DRAWING NUMBER: 100-10000		LEADER SPOT
DETAILED DRAWING		100-10000
SURFACE TEXTURE		100-10000
SCREW THREADS		100-10000
GENERAL SPECIFICATIONS		100-10000
 Defiant Diesel Address Division of Business Systems Company 100-10000		100-10000
TITLE GAGE - SPLINE, STARTER GENERATOR GEARSHAFT NO-GO (OVER HAUL)		100-10000
MODEL 100-10000		100-10000
PRINT DATE 10-17-17		100-10000
SCALE 1:1000		100-10000
DATE 10-17-17		100-10000
CODE NUMBER D 73342		100-10000
DRAWING NO. 6891390		100-10000
REMARKS 100-10000		100-10000

-5-
1946

卷之三